



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4030-041
Job Sheet 167227



Part No: D4030-041

Job Qty: 1 ea

Part Name: Long Basket Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/26/17

Job Tracking No:

Due Date: 12/1/17

Created By: Mario Poulin

Type: Stock

Description:

Customer: Helistream Inc (CHEST01)

3000 Airway Avenue, Suite 350 Costa Mesa, CA, 92626 USA ph:(714) 662-3163 fx:(714) 662-1687.

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/30/17	0.00	0.00	Start Up Stores/Pkg1		
100	Packaging	1 pcs		11/30/17	0.00	0.00	Packaging1		
110	HandFinish	1 pcs		12/1/17	0.00	1.03	HandFinish4		
120	QC	1 pcs		12/1/17	0.00	0.00	QC5		
130	Packaging	1 pcs		12/1/17	0.00	0.00	Packaging3		
140	QC21-SA	1 Ea		12/1/17	0.00	0.00	QC21		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	AN3-14A 5008899	4	177	0	0
	AN3-16A 5008900	2	35	0	0
	AN310-4 5008901	3	115	0	0
	AN310C4 5008902	2	31	0	0
	AN4-12 5008903	3	38	0	0
	AN5-17A 5008904	4	19	0	0
	D2530 5008859	1	16	0	0
	D2535 5008857	2	25	0	0
	D2537 5008858	2	33	0	0
	D3913-041	1	2	0	0
	D3914-041	1	4	0	0
	D3917-3 5008852	6	64	0	0
	D3953-17 5008854	2	22	0	0
	D3953-19 F163704	1	12	0	0
	D3953-21 5008856	1	14	0	0
	D3953-3 5008859	2	18	0	0
	D3953-7 5008840	2	9	0	0
	D3953-9 5008857	2	12	0	0
	D3969-3 F161502	1	11	0	0
	MS21042L3 5008906	6	879	0	0
	MS21042L5 5008907	4	488	0	0
	MS24665-151 5008908	3	95	0	0
	MS24665-300 5008909	2	41	0	0
	NAS1149C0432R 5008910	2	1,402	0	0
	NAS1149F0332P 5008911	8	3,293	0	0
	NAS1149F0432P 5008912	6	923	0	0
	NAS1149F0563P 5008913	4	180	0	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																			
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																			
Description Work O Change No: _____ Operation: _____ Revision: _____ PART NO: _____ D4030-041 Start up Operation Mfg Date: 11/14/17 Job No: 167227 S009630 DART Aerospace Long Basket Assembly (350) <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="2">Root Cause</th> </tr> </thead> <tbody> <tr><td>Environment</td><td>☐ No Re-verification</td></tr> <tr><td>Design</td><td>☐ Operator</td></tr> <tr><td>Doc/Data</td><td>☐ Offset/Setup</td></tr> <tr><td>Equip/Tooling</td><td>☐ Supplier</td></tr> <tr><td>Handling/Pre</td><td>☐ Training</td></tr> <tr><td>Material</td><td>☐ Use for Testing</td></tr> <tr><td>Internal Transport</td><td>☐ Poor Information</td></tr> <tr><td>Tribal Knowledge</td><td>☐ Rushing</td></tr> <tr><td>LOA</td><td>☐ Product Improvement</td></tr> <tr><td>Substation</td><td>☐ Process Improvement</td></tr> <tr><td>Past Expiry Date</td><td>☐ Manufacturing Process</td></tr> <tr><td>Misidentified</td><td>☐ Past Due</td></tr> </tbody> </table> Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>☐ Cuffs</td> <td>☐ Contamination</td> <td>☐ Out of Sequence</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ Countersink</td> <td>☐ Off-set</td> </tr> <tr> <td>☐ Heat Treat</td> <td>☐ Cut Too Short</td> <td>☐ Mislabeled</td> </tr> <tr> <td>☐ Wave/Twist in Tube</td> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Fit/Function</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Misaligned/off center</td> </tr> </table> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td>☐ Positioned Wrong</td></tr> <tr><td>☐ Outside Dimensions</td></tr> <tr><td>☐ Over/Under tolerance</td></tr> <tr><td>☐ Part Incorrect</td></tr> <tr><td>☐ Part Lost/Missing</td></tr> <tr><td>☐ Part Moved</td></tr> <tr><td>☐ Drawing</td></tr> <tr><td>☐ Finish</td></tr> <tr><td>☐ Misread</td></tr> <tr><td>☐ Turning Sequence</td></tr> </table>					Root Cause		Environment	☐ No Re-verification	Design	☐ Operator	Doc/Data	☐ Offset/Setup	Equip/Tooling	☐ Supplier	Handling/Pre	☐ Training	Material	☐ Use for Testing	Internal Transport	☐ Poor Information	Tribal Knowledge	☐ Rushing	LOA	☐ Product Improvement	Substation	☐ Process Improvement	Past Expiry Date	☐ Manufacturing Process	Misidentified	☐ Past Due	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Crushing	☐ Countersink	☐ Off-set	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Positioned Wrong	☐ Outside Dimensions	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Drawing	☐ Finish	☐ Misread	☐ Turning Sequence
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				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																			
OTHER : _____																																																							

Part Specifications

Specifications could not be found.

Plex 10/26/17 5:45 PM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
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Note: DWG REV D SHEETS 1,3,4 IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM

Ship Via:

Bill of Materials

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Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
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140	QC21-SA	1 Ea		12/1/17	0.00	0.00	QC21		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	AN3-14A	4	165	0	0
	AN3-16A	2	32	0	0
	AN310-4	3	61	0	0
	AN310C4	2	46	0	0
	AN4-12	3	35	0	0
	AN5-17A	4	97	0	0
	D2530	1	26	0	0
	D2535	2	23	0	0
	D2537	2	31	0	0
	D3917-3	6	55	0	0
	D3953-17	2	18	0	0
	D3953-19	1	10	0	0
	D3953-21	1	12	0	0
	D3953-3	2	12	0	0
	D3953-7	2	21	0	0
	D3953-9	2	21	0	0
	D3969-3	1	10	0	0
	MS21042L3	6	1,172	0	0
	MS21042L5	4	382	0	0
	MS24665-151	3	92	0	0
	MS24665-300	2	38	0	0
	NAS1149C0432R	2	1,162	0	0
	NAS1149F0332P	8	2,662	0	0
	NAS1149F0432P	6	917	0	0

110-HandFinish	NAS1149F0563P	4	176	0	0
	D3913-041	1	2	0	0
	D3914-041	1	5	0	0
Part Specifications					
Specifications could not be found.					

Plex 11/14/17 8:33 AM dart.willems.sian